Work Order Tuesday, June 29,			;									Page 1
Item ID: D Revision ID:	03535-39		· A	ccept					Setup			
	/earshoe /29/2010 /6/2010	Start Qty: 16.00 Req'd Qty: 16.00			Cust Item I Customer:	D:				Stop		
	Process Plan	:	Date: 10 629	Tooling: SPC (Y/N):		nte:			Run	Start Stop		
Sequence ID/ Work Center ID		Operation Description	**	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr D3535	Revis Rev I	sion Nbr										
100 Waterjet		FLOW WATER JET Memo		0.00				(<u>R</u>	<u> </u>	८-14		
FLOW CNC Waterjet)	1-Cut as per Deburr if nec			□2-					`	(1)	
; 110 		QC2- Inspect parts off ma	achine FAI/FAIB	0.00				ı İ.	7 105	8-14		

120 QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

Quality Control

Memo

Dail AcidSbace Lil	Dart Aerosp	ace L	.td
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W/O:			W	ORK ORDER CHA	NGES					•
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Work Order ID 60233

Tuesday, June 29, 2010 11:43:18 AM



Page 2

Item ID:

D3535-39

Accept

Setup Start



Revision ID:

Item Name:

Wearshoe

Start Date: 6/29/2010 Required Date: 7/6/2010

Start Qty: 16.00

Req'd Qty: 16.00



Cust Item ID: Customer:

Tool ID

Reference:

Approvals:	
zxppi orais.	

Process Plan: Date:

Tooling:

Date:

Date:

Tool # Plan

Code

Run Start

Reject

Qty

Reject

Stop

Stop



Number Stamp

Insp.

Sequence ID/ **Work Center ID**

130

Brake NC

Brake NC

Operation Description

Set Up/ **Run Hours**

Date:_____

0.00

0.00

SPC (Y/N):

NC BRAKE

Memo

Deburr if necessary ☐ Form, on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. □Identify as D3535-41 □Form Joggle on brake using Jig DT8158 as per

Dwg D3535

140

Quality Control

QC5- Inspect part completeness to step on W/O

Accept

Qty

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M 119588

Memo

Memo

0.00

17 BR 10-8-23.

W/O:			WO	RK ORDER CHAI	NGES					
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Work Orde Tuesday, June 2													Page 3	
Item ID: Revision ID: Item Name:	D3535-39 Wearshoe			Accept					S	Setup	Start Stop			
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170		Identify as per dwg & Stor	ck Location	0.00 SI - CP-1:	=) Jy	10/08/	23							

Packaging

Packaging

Memo

0.00

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

mc 10/08/23 95}

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Picklist Print

Tuesday, June 29, 2010 11:43:22 AM

Work Order ID: 60233

Parent Item: D3535-39

Parent Item Name: Wearshoe

Start Date: 6/29/2010

Required Date: 7/6/2010

Page 1

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B

As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	69.9836	0.951	16.01684	16. 1B10-	2-14	
				Location	!	Loc	<u>Oty</u>	Loc Code					

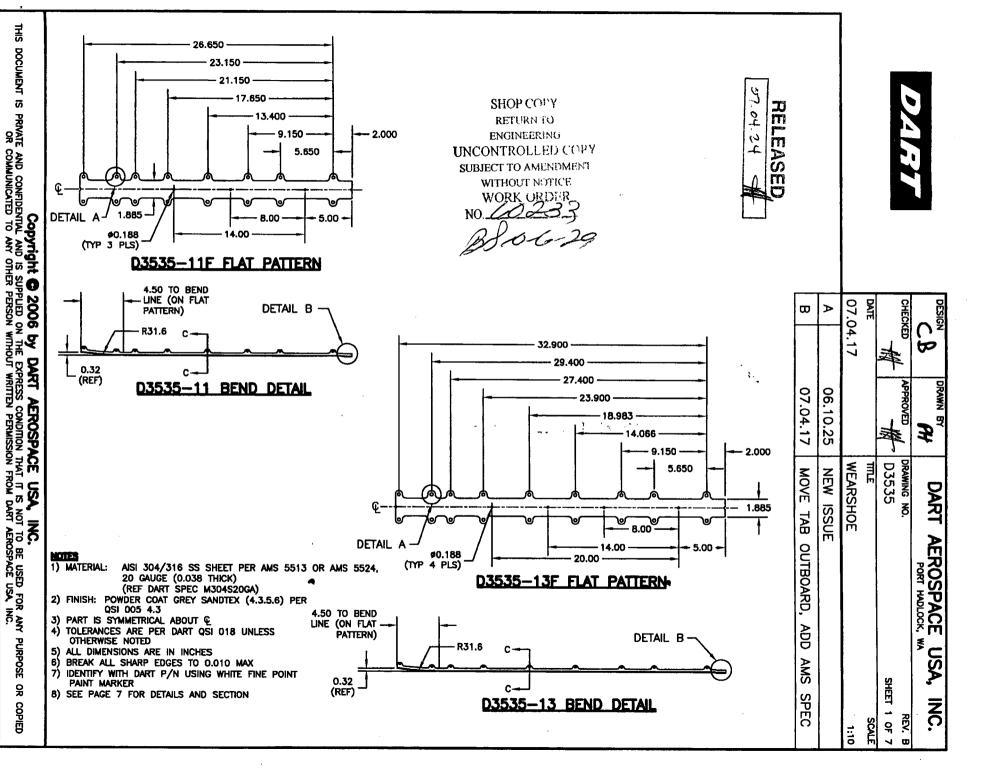
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	112885	2.7475			
	113062	1.1083		·	
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Dart Ae	rospace	e Ltd						18. ⁷	,
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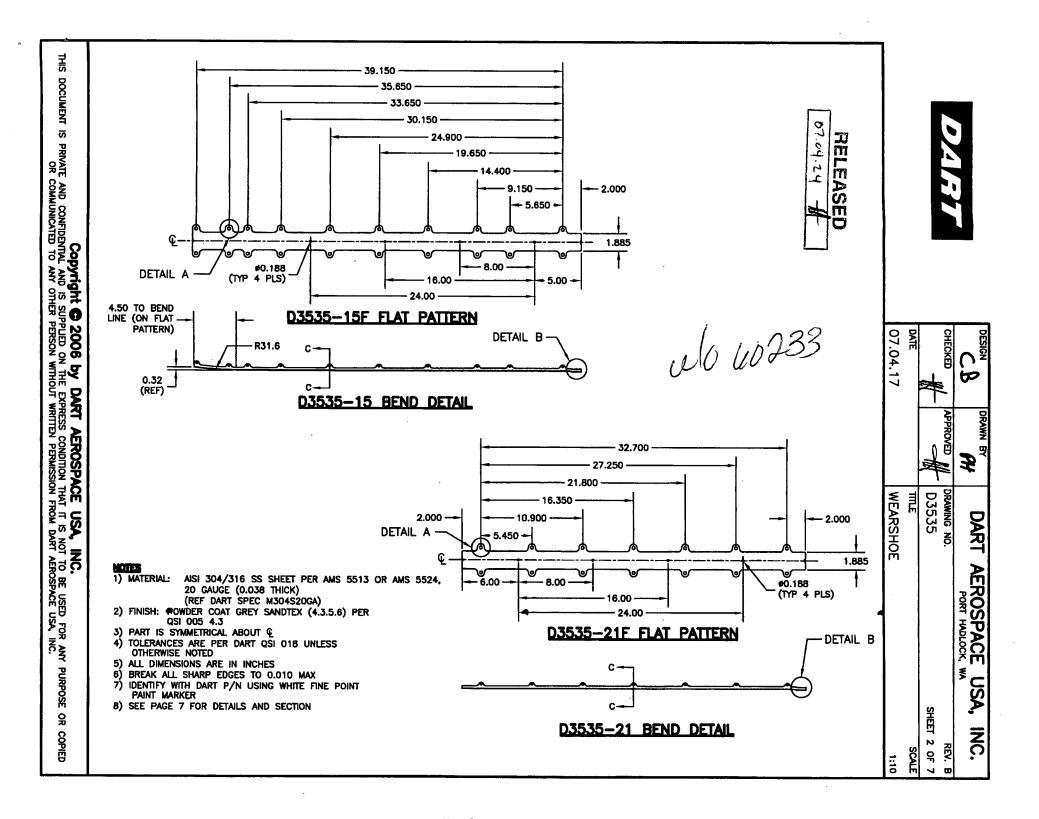
DART AEROSPACE LTD	Work Order:	66233
Description: Wearshoe	Part Number:	D3535-39
Inspection Dwg: D3535 Rev: B		Page 1 of 1

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29.275	+/-0.010	29.274	بخ		7	
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19.750	+/-0.010	19,750	*		7	
17.750	+/-0.010	17,750	8		7	
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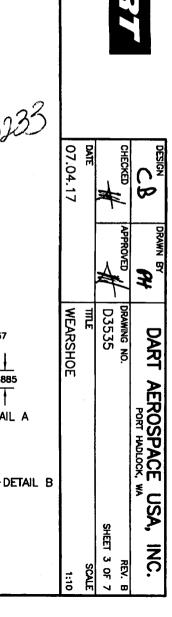
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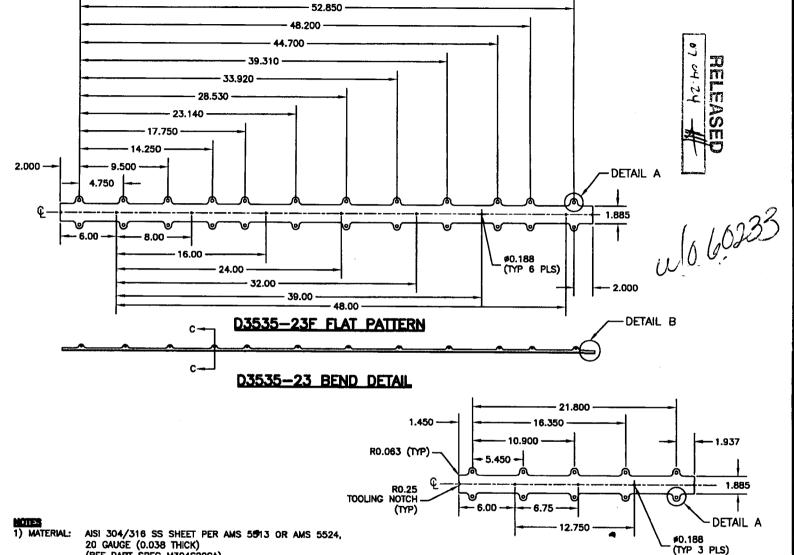


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D3535-25F FLAT PATTERN

D3535-25 BEND DETAIL

20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT &

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PURPOSE

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COPIED

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL SHARP EDGES TO 0.010 MAX

7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION

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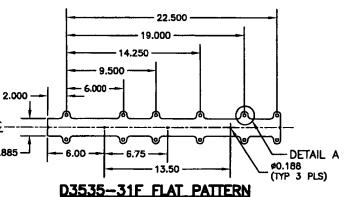
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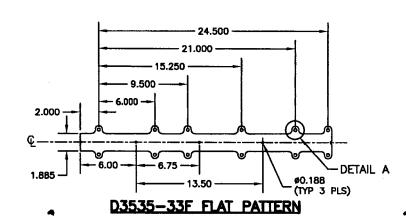


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D3535-31 BEND DETAIL



AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 1) MATERIAL: 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

1.885

3) PART IS SYMMETRICAL ABOUT &
4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL SHARP EDGES TO 0.010 MAX

IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION

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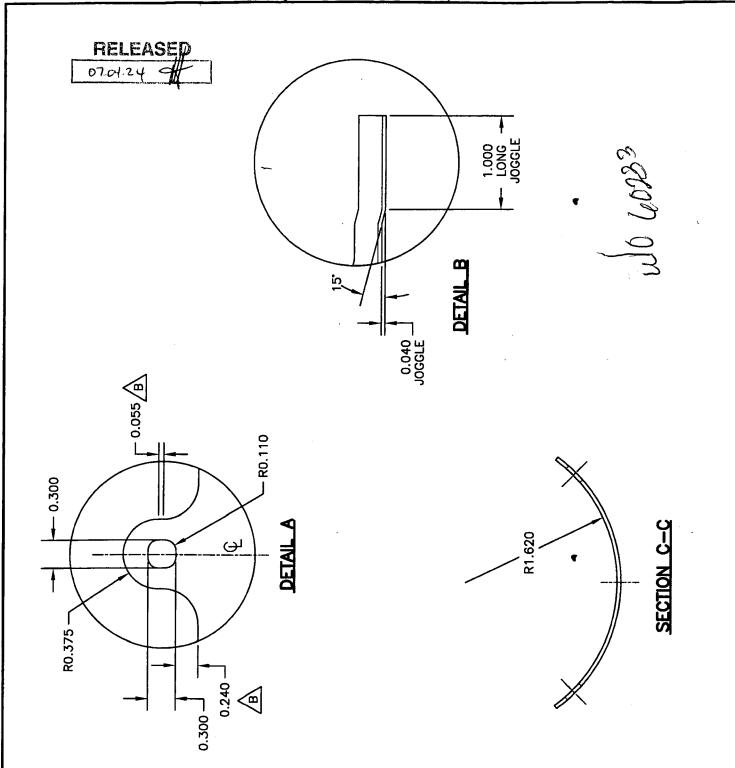
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07.04.17		WEARSHOE	1:1



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